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15 The present invention relates to an absorbent web of entangled synthetic eccentric bicomponent fibers, especially to such webs having high levels of absorbency and good structural integrity at high temperatures.

Fibrous webs for absorbing a wide variety of liquids are widely used for a variety of purposes. Fibrous webs are made from a plurality of individual fibers which are bonded to one another to provide the web some degree of structural integrity, so that it can retain its shape during manufacture, handling, and/or use. Void volume within the web provides capacity for absorbing and retaining liquids. One of the disadvantages of fibrous webs is that the web, especially at elevated temperatures, can lose integrity and consequently result in fibers becoming loose and separate from the web. This is particularly a disadvantage in such applications as absorbing oil from food during cooking, when exposure to high temperature results in loss in integrity of the web. Typical temperatures experience during stove-top cooking, for example, can range from about 120 C to about 175 C.

Unfortunately, conventional synthetic fibers that are highly resistant to loss of integrity at high cooking temperatures typically have low oil absorbency, whereas fibers

that have high oil absorbency typically have poor integrity at high temperature. Conventional thermal or adhesive bonding throughout the thickness of the fibrous web can improve high temperature integrity, however such techniques also adversely affect absorbency.

5           It is an object of this invention to provide fibrous webs that are both absorbent and have good structural integrity at high temperatures.

          It is yet another object of this invention to provide methods of using such fibrous webs.

          These and other object and benefits of the invention may become apparent to  
10 those of ordinary skill in the art may be achieved as a result of the invention as described in the specification and defined in the claims which follow.

          All percentages are by weight of the total composition or product unless otherwise indicated. All averages are weight averages unless otherwise indicated. All products or processes that comprise one or more elements disclosed or claimed herein may alternately  
15 consist of or consist essentially of any elements disclosed or claimed herein.

### **SUMMARY OF THE INVENTION**

          The present invention provides a web of entangled synthetic fibers, wherein said fibers are eccentric bicomponent fibers. The present invention further provides a method  
20 of absorbing oil from foods comprising contacting a web of entangled, eccentric bicomponent fibers with oil-containing food prior to, during, or subsequent to preparation of such foods, especially but not limited to during or subsequent to cooking such foods wherein said web is exposed to temperatures at above about 120 C.

### **BRIEF DESCRIPTION OF THE DRAWINGS**

25           While the specification concludes with claims particularly pointing out and distinctly claiming the present invention, it is believed that the present invention will be better understood from the following description in conjunction with the accompanying drawings in which like reference numerals identify identical elements and wherein:

          FIGURE 1 is a perspective view of an absorbent web according to the present  
30 invention;

FIGURE 2 is a cross-sectional view of a preferred web of the present invention;

FIGURE 3 is a cross-sectional view of an eccentric bi-component fiber useful in the webs of the present invention;

FIGURE 4 is a flow diagram for a process for making fibrous webs according to the present invention; and

FIGURE 5 is a cross-sectional view of an alternative eccentric bi-component fiber useful in the webs of the present invention.

### **DETAILED DESCRIPTION OF THE INVENTION**

The webs of the present invention are entangled webs. By "entangled web" what is meant is that the fibers of the web are mechanically bonded to each other due to the individual fibers interlocking, i.e., "entangling" with one another. Optionally, at least one surface of the web, preferably both top and bottom surfaces, are "glaze" or "surface" bonded, as defined herein. It has been found that surface bonding at the surface of the web can significantly reduce linting, while allowing the web to retain excellent absorbency and maintain relatively low density and softness. Such surface bonding also enables lower density webs to be provided which have high absorbency normally attributable to low density, in combination with low levels of lint normally attributable to more highly entangled, higher density webs.

Typically, in conventional thermally-bonded webs, the melted material of the fibers or other thermal bonding agent flows into the interstitial void spaces to form bond sites, thereby reducing both the number and size of the interstitial void spaces between the fibers. This reduces the available free surface area on the fiber surfaces for absorbing liquids. The size of the interstitial void spaces may be further reduced by fabric compaction in and adjacent to bond sites during calendar roll thermal bonding. Surface bonding avoids these problems by entangling to form a low density web, and thermally or adhesively bonding the surface(s), thereby minimizing the degree of thermal or adhesive bonding throughout the entire web necessary to minimize linting.

In particular, the preferred absorbent fibrous structure of the present invention comprises an entangled web of synthetic fibers, the web having a top surface and a

bottom surface, wherein at least one of said top surface and said bottom surface are surface bonded. Preferably both the top and bottom surfaces are surface bonded. Preferably the surface bonded surface or surfaces are thermally bonded. Thermal bonding can be accomplished by heating the fibers of the web at the surface to a temperature above the  $T_g$  or  $T_m$  of fiber material and then cooling the material while adjacent fibers are in contact with one another. Surface bonding can also be achieved by chemical bonding, e.g. with adhesives, such as but not limited to hot melt adhesives (e.g., such as are available from Hysol, Inc. hot melt adhesive numbers 6009 and 7480). Surface bonding as defined herein does not mean bonding by mechanical entanglement of the fibers or hydrogen bonding. Thus, fibers at the surface of the webs of the present invention may be bonded by entanglement and are further "surface" bonded (e.g., thermal or chemical bonding, but not including hydrogen bonding). Additionally, one or more edges of the web may be surface bonded.

By surface bonding of the surfaces or edges, what is meant is that bonding occurs at the surface of the web, however a center region of the web remains unbonded (other than by mechanical entanglement and hydrogen bonding) or is bonded to a lesser extent compared to the surface. Preferably surface bonding occurs to a depth less than the thickness of the web, more preferably to a depth less than one-half the thickness of the web, such that that center of the web is not surface bonded even when both top and bottom surfaces of the web are surface bonded. Preferably a relatively thin layer of the web structure is bonded by surface bonding. In the event that some surface bonding does extend through the entire thickness of the web, the degree of bonding should be low enough such that the web retains both good absorbency and low density. In such instances of thermal bonding through the entire thickness, there will preferably be a gradient in the degree of thermal bonding through the thickness of the web with a higher degree of bonding at the surfaces and/or edges in relation to the interior volume of the web.

The fibrous web of the present invention is nonwoven. The nonwoven web may be made by any of a number of techniques common in the art including, but not limited to; carding, spunbonding, air laying, and wet laying. The web may also comprise one ply, or

layer, or a plurality of plies. A combination of plies made by different nonwoven web manufacturing techniques may also be used. Multi-ply webs may be laminated or non-laminated. Preferably, the web structure is made by carding or is spunbonding, most preferably carding.

5       The webs of the present invention comprise a plurality of synthetic fibers, preferably polymeric fibers. Fiber lengths are preferably at least about 2 cm, more preferably at least about 2.5 cm, more preferably at least about 3.75 cm. Although there is not necessarily an upper limit to fiber length, preferably fiber length will be about 10 cm or less, more preferably about 8 cm or less, and most preferably about 5.5 cm or less.

10       The webs of the present invention comprise eccentric bicomponent fibers. The term "bicomponent" as used herein refers to fibers having at least two discrete structural portions of a fiber. The two discrete structural portions will generally be made of different polymeric compositions. Eccentric bicomponent fibers means fiber having at least two distinct polymeric plies each disposed adjacent at least one other ply with a  
15       contact point between plies running along the longitudinal axis of the fiber. Eccentric bicomponent fibers will have at least two components, wherein there is no component having 90% or more of its exterior surface area enclosed by other components of the fiber. Such fibers having a component with at least 90% of its surface area enclosed by other components is referred to as a sheath-core bicomponent fiber or a concentric, bicomponent fiber. Referring now to Figure 3, shown is a cross-section of an eccentric  
20       bicomponent fiber 30 shows a first ply 32 and a second ply 34 eccentrically disposed against the first ply 32. Figure 5 shows a cross-sectional view of an alternative eccentric bicomponent fiber 36 having a first ply 37 and a second ply 38.

      The synthetic fibers may be made from any polymers known in the art, including  
25       homopolymers as well as copolymers made from two or more monomers. The fibers may also be made from a single polymer species or from a blends of polymers. The fibers may further include any common additives which are safe and effective for their intended purpose and for the intended purpose of the fibrous web, including but not limited to surfactants (especially blooming surfactants incorporated into the polymer melt during  
30       formation and surfactants applied to the surface of the formed polymeric fiber).

Suitable polymers include, but are not limited to: polyolefins, such as polypropylene (PP), polyethylene (PE), poly 4-methylpentene (PMP), and polyethylene terephthalate (PET); polyamides, e.g. nylon; cellulosic derived polymers such as regenerated cellulose and rayon; polyesters, or combinations and/or blends thereof.

5 Preferred polymers include PP, PE, and PET.

The polymer or polymers used that are used desirably retain structural integrity at temperatures above the intended temperature conditions during use. Polymers which are amorphous in nature can be described in terms of their glass transition point (T<sub>g</sub>). Polymers which are crystalline in nature can be described in terms of their melting point  
10 (T<sub>m</sub>). Preferably the webs of the present invention will comprise fibers comprising a combination of components with at least one component being a polymeric material with T<sub>g</sub> or T<sub>m</sub> of at least 120 C, more preferably at least about 175 C, more preferably at least about 200 C, and a second component comprising a polymeric material that is more oleophilic compared to the first component, typically with a T<sub>g</sub> or T<sub>m</sub> of less than 120 C

15 Preferably the surface area exposed to the ambient environment of the first ply is in the range of from greater than 10% to up to but not including 90% of the total surface area of the fiber, more preferably from about 50% to up to but not including 90%. The surface area of the second, oleophilic ply is from greater than 10% up to but not including 90%, preferably from greater than 10% to about 50%.

20 By providing eccentric bicomponent fibers with a combination of highly oleophilic polymeric material as at least one component and a high T<sub>g</sub> or T<sub>m</sub>, although typically less oleophilic (or more hydrophilic) second component to provide structural integrity at high temperatures, entangled webs can be produced which combine both high oil absorbency and good structural integrity even at high cooking temperatures. By  
25 providing the webs in the form of entangled webs, as described in further detail below, rather than the thermally or adhesively bonded, high absorbency can be obtained without suffering from undue loss in absorbency.

The oleophilic ply, for example, may comprise polyolefins such as polypropylene (PP), polyethylene (PE), poly 4-methylpentene (PMP), or blends thereof, preferably  
30 polypropylene (PP) or a blend of polypropylene (PP) and poly 4-methylpentene (PMP).

The high Tg or Tm material is capable of being formed into a fiber and have sufficient heat stability to maintain web integrity up to at least about 120 degrees C, more preferably 175 degrees C, and even more preferably at least up to about 200 degrees C. This material may include, but is not limited to: polyester, nylon, polyethylene terephthalate (PET), rayon, regenerated cellulose, or combinations and/or blends thereof.

Preferably the webs of the present invention comprise at least about 55% by weight bicomponent fibers selected from eccentric and concentric bicomponent fibers. The webs hereof will comprise at least about 25% by weight eccentric fibers, but may also comprise at least about 55%, 75%, 90% or even 100%, eccentric bicomponent fibers.

Bicomponent fibers suitable for use in the present invention may be obtained from Fiber Innovation Technology, Inc., Johnson City, Tennessee, USA.

The nonwoven web may be entangled, or mechanically interlocked, by any number of techniques common in the art including, but not limited to: needling (alternately known as felting), hydroentangling, or other non-melt bonding/nonadhesive techniques, or combinations thereof. Preferably, the fibers are entangled by either hydroentangling or needling, most preferably needling. Also preferably, the web is cross lapped subsequent to web formation and prior to entangling. Cross lapping can be used to increase basis weight and caliper of the web, and is especially preferred for nonwoven webs (such as but not limited to carded webs and wet laid webs) which are relatively weak in one planar direction, e.g., weaker in the cross direction relative to the machine direction. Cross lapping can also improve uniformity of the caliper and basis weight of the web. A preferred technique for making cross lapped webs is festooning. Methods for cross lapping and festooning as used herein are well known to those in the art.

The fibers are preferably entangled by application of entangling force applied in the direction that is normal to the plane of the web to maximize void space, that is, the z direction as shown in Figures 1 and 2.

The web is then thermally bonded at least at one surface of the web, preferably at both the top surface and the bottom surface, and optionally at one or more edges of the web. Preferably thermal bonding is accomplished by melt bonding of the fibers at about, or above, the Tg or Tm, as may be applicable, of the polymeric material of the fiber.

With respect to bicomponent fibers, the minimum thermal bonding temperature will correspond to about the T<sub>g</sub> or T<sub>m</sub> of the polymeric material with the lowest T<sub>g</sub> or T<sub>m</sub>. It is preferred to thermally seal the surfaces of the web at the lowest temperature practicable in order to maximize absorbent capacity of the web. Preferably, the thermal bonding temperature is no more than about 25 C, more preferably no more than about 10 C, more preferably no more than about 5 C, most preferably no more than about 2 C above the T<sub>g</sub> or T<sub>m</sub>, the lowest of which may be applicable, of the lowest melting or glass transitioning exterior component of the fiber. Thermal bonding also should preferably be applied using the least pressure applied to the web as necessary in order to thermally bond the surface. Preferably the heat rolls or belts used do not substantially compress the web during processing.

The preferred polymeric materials for thermal bonding will have a T<sub>g</sub> or T<sub>m</sub>, as may be applicable, of at least about 120 C, more preferably at least about 140 C, most preferably at least about 150 C, most preferably at least about 160 C (e.g., PET's having T<sub>m</sub> of 240 – 260 C and PP's with T<sub>m</sub> of about 160 C).

It has been found that the combination of thermal bonding at the web surface with entangling can provide surprisingly high absorbency in combination with low levels of linting. Preferably, entanglement forces normal to the plane of the web are applied with high needling frequency on a unit area basis. For needling processes, the needling frequency is preferably at least about 150 needle strokes/cm<sup>2</sup>, more preferably at least about 180 needle strokes/cm<sup>2</sup>, more preferably at least about 200 needle strokes/cm<sup>2</sup>, most preferably at least about 215 needle strokes/cm<sup>2</sup>. Needling penetration (the distance by which the tip of the needle penetrates through entire thickness of the web and beyond the edge of the far surface of the web, measured from the surface opposite of where the needle is inserted) can be adjusted by those of ordinary skill in the art and will depend upon the starting density, basis weight, and caliper, as well as the desired post-needling density, basis weight, and caliper, and the type of needle used. It has been found that surprisingly low needle penetration distances through the web, in combination with high stroke density, can provide surprisingly low linting values while retaining good absorbency and overall web integrity when combined with surface bonding. Exemplary



needling processes are disclosed in US Patent 3,859,698, issued January 14, 1975 to M. Okamoto et al., incorporated in its entirety herein.

Needling is preferably applied to both the top and bottom surfaces of the web. Especially preferred is to apply needling to one surface of the web in a first stage of entanglement referred to as a tacking stage, e.g. the top surface, and subsequently apply a  
5 second or final stage of needling to both the top and bottom surfaces.

The absorbent webs of the present invention preferably have relatively low density, in order that they may provide high absorbent capacity, softness, and/or cleaning ability. The density of the present webs is preferably about  $100 \text{ mg/cm}^3$  or less, more  
10 preferably about  $75 \text{ mg/cm}^3$  or less, most preferably about  $50 \text{ mg/cm}^3$  or less. Minimum density is governed primarily by practical limitations, however the density will preferably be at least about  $10 \text{ mg/cm}^3$ , more preferably at least about  $25 \text{ mg/cm}^3$ , most preferably at least about  $40 \text{ mg/cm}^3$ .

Thickness of the webs of the present invention can vary widely. In general, the  
15 webs will be at least about 2 mm thick (in the z direction). Single ply layers or webs will typically be up to about 50 mm due to practical considerations, however it is not meant to necessarily limit the present invention to such upper or lower limit. Preferably the webs of the present invention will be from about 2 mm to about 10 mm thick, more preferably from about 2.5 mm to about 5 mm thick. It is also contemplated to layer several plies of  
20 web and, prior to or subsequent to layering, thermally bond the outermost top and/or bottom surfaces of the multi-ply web. Basis weight of the webs of the present invention is preferably from about  $100 \text{ g/m}^2$  to about  $500 \text{ g/m}^2$ , more preferably from about  $125 \text{ g/m}^2$  to about  $250 \text{ g/m}^2$ , most preferably from about  $150 \text{ g/m}^2$  to about  $185 \text{ g/m}^2$ .

As previously discussed, the webs of the present invention are highly oil  
25 absorbent. Oil absorbency can be measured according to the Oil Absorbency Test described below in the Test methods section. Oil absorbency will depend on factors that including but not limited to, polymer selection, fiber shape and length, degree of thermal bonding, degree and conditions of fiber entanglement, and web density. The webs will preferably have an Oil Absorbency, as measured according to the test below, at ambient  
30 temperatures ( $22^\circ \text{C}$ ), hereinafter referred to as the Ambient Temperature Oil Absorbency,

or at least about 7 g/g, preferably at least about 10 g/g, more preferably at least about 12 g/g, most preferably at least about 15 g/g. Also preferably, the absorbent web will be made from fibers having sufficient oleophilicity and high temperature stability such that the Oil Absorbency at the elevated temperature of 120 C, hereinafter the High Temperature (120 C) Oil Absorbency is at least about 6 g/g, preferably at least about 9 g/g, more preferably at least about 11 g/g, most preferably at least about 13 g/g. Further, the preferred webs hereof absorb oil preferably over water.

The preferred, surface bonded structures of the present invention have especially low linting, while retaining good absorbency and low density, as a result of the surface thermal bonding of the web. Linting can be measured according to the Linting Value test in the Test Methods section below. The webs will preferably have a Linting Value of about 6.6 mg/cm<sup>2</sup> or less, preferably about 5.0 mg/cm<sup>2</sup> or less, more preferably about 3.3 mg/cm<sup>2</sup> or less, most preferably about 1.0 mg/cm<sup>2</sup> or less. Accordingly, surface bonding at the surfaces of the web should preferably be applied to the degree necessary in order to reduce linting to at or below the desired level.

The fibrous web may also include a line of weakness, including, but not limited to, a line of perforations, laser scores, or tear-initiating notches, which would facilitate the use of a portion or part of the fibrous web.

The fibrous web of the instant invention can be of various sizes and shapes. It may optionally be wound on a roll and provided in a dispensing package. The web of the present invention can be used by contacting it with oil. In a preferred application it is contact or placed in oil communication with food prior to, during, or subsequent to preparation of the food, including for example cooking of the food. In a preferred application, such as described in US patent application Serial No. 09/510,164, referred to above and incorporated herein by reference, the fibrous web is used to remove oil, fat, or grease (hereinafter collectively referred to as grease) during and after the preparation of food. An absorbent fibrous web of the instant invention is placed adjacent to food during the cooking of the food, such as, but not limited to, in a frying pan or on top of soups and chilies. During cooking, the absorbent fibrous web preferentially absorbs the grease. After the food is cooked, the absorbent fibrous web is removed and discarded. Also, an

absorbent fibrous web of the instant invention may be used to blot excess grease off of foods such as, but not limited to, pizza, pork products (e.g., bacon), beef products, poultry, and including ground meat products of all types (e.g. hamburgers, sausages, etc.). The webs can be used at ambient temperatures, but can also be used at cooking  
5 temperatures, and are especially useful at cooking temperatures typically encountered during stovetop, microwave, or oven cooking, e.g. about 65 C to about 250 C. It is especially desirable that the web retain structural integrity at temperatures of 100 C, preferably at 120 C, more preferably at 150 C and above, including up to about 250 C. By structural integrity, what is meant is that the web retains integral in one piece during  
10 normal, intended use, and the polymeric components therein do not otherwise disintegrate or chemically degrade.

In general, the method comprises placing the web in oil communication with food. Preparation of food includes, but is not limited to, manipulating, mixing, cooking, heating, or otherwise treating or modifying or handling food. By "oil communication",  
15 what is meant is the article is positioned to absorb grease from food before, during or subsequent to preparation. Oil communication can be provided but is not necessarily limited to the following categories: 1) the web is placed in admixture with or in food; 2) the web is placed in direct contact with the surface of food or a part thereof; 3) the web is positioned to come into contact with grease during preparation of food, but is not  
20 necessarily in direct contact with the food.

The fibrous web according to the present invention may be admixed with food. For example, the fibrous web may be stirred or swirled around or through the food or the food may be stirred around the web. This method ensures that the web contacts the surface area of the food for maximum absorption. This method is especially useful to  
25 absorb grease during cooking of foods such as, but not limited to, ground beef.

The fibrous web may be used in contact with food. Because of the web integrity of the fibrous web of the instant invention, the fibrous web has little or no linting, sticking, pilling or shredding. For example, one method is to contact foods with the web. The foods may be either solids (such as, but not limited to, pizza) or liquids (such as, but  
30 not limited to, soups and stews). "Contacting" may include, but is not limited to,

padding, blotting, dragging over, or wrapping, etc. Another method is to wrap the food in the fibrous web and squeeze the food slightly to contact even more surface. Another method is to use the fibrous web as a hot pad to transport foods. Because the fibrous web of the instant invention preferably consists of a relatively thick material, the fibrous web may act as a hot pad and at the same time absorbing the grease from the food's surface. For example, the fibrous web can be used to move foods such as, but not limited to, meats or roasts from a baking pan to serving platter. Another method of using the fibrous web includes covering food with the web to keep foods warm longer due the insulation effects of the web while removing surface grease at the same time. Another use for the fibrous web includes wrapping food, such as, but not limited to, leftovers, with the fibrous web to remove grease during storage. Another use includes placing food on top of the fibrous web and allowing the grease to absorb into the web while allowing fluids such as, but not limited to, water or other aqueous liquids to pass through the interstitial voids of the web, similar to a draining device having a surface with apertures or other means for allowing fluids to drain, such as, but not limited to, a colander. Additionally, the fibrous web may be placed adjacent to such a draining device, such as, but not limited to a colander, and then food may be placed on top of the web, thereby allowing fluids such as, but not limited to, water or other aqueous liquids to pass through the web and the draining device. Furthermore, the fluids that pass through the web in this manner, with or without the use of a draining device, may be collected and used for foods, such as, but not limited to, making flavorful low fat gravies and sauces.

The fibrous web may be used in a manner such that it is in oil communication with the grease of the food but not in contact with the food. For example, the cooking container may be tipped to one side so that the grease collects on that one side. Then, the fibrous web may be placed on that side of the pan for absorption. It is also beneficial, but not required, to use a utensil to keep the food in a position other than the one side of the pan that is collecting the grease during tipping of the pan. Another example includes using the fibrous web of the instant invention as a "spatter shield" to prevent splattering from the cooking pan onto a stovetop, microwave, or other surrounding areas. While other absorbent articles in the prior art may melt from contact with a cooking pan at high

temperatures, the fibrous web of the instant invention may be placed above the food being prepared and even in contact with the cooking container during cooking. When used in this manner, the fibrous web may wholly or partially cover the cooking container to stop the grease from splattering outside the container. This eliminates the messy cleanup of the surrounding area. Another example includes using the fibrous web of the instant invention to absorb the residual grease left in a cooking container after cooking by wiping or cleaning the pan with the fibrous web. This is especially effective when the cooking pan is still hot and the grease has not solidified.

As mentioned above, the fibrous web may also be used in a microwave. One method is to use the product as a cover or splatter shield (as described above) in the microwave. Another method includes wrapping the food in the fibrous web during cooking in the microwave. This allows steam to safely escape while capturing the splattering grease. The foods are then able to crisp in the microwave because the removal of the grease from the food by the fibrous web helps to prevent the food from becoming soggy.

Additionally, the present invention includes a system comprising the fibrous web and information that will inform the consumer, by written or spoken words and/or by pictures, that use of the fibrous web will absorb grease. Accordingly, the use of packages in association with information that will inform the consumer, by words and/or by pictures, that use of the fibrous web will provide benefits such as, but not limited to, improved absorption of grease is important. The information can include, e.g., advertising in all of the usual media, as well as statements and icons on the package, or on the fibrous web itself, to inform the consumer of the unique grease removal capabilities. The information may be communicated only by verbal means, only by written means, only by pictorial means, or any combination thereof. Information can be provided in a form of written instructions placed on or in packaging for the fibrous web, on the fibrous web itself, or on a separate article (such as, but not limited to, a piece of paper) packaged with the fibrous web. Obviously, the information need not be included directly with the product to constitute a system within this aspect of the invention. That is, for example, if

a fibrous web is sold and advertisements are communicated generally about the fibrous web, this would constitute a system of this invention.

5 Additionally, the webs of the present invention can be used for absorption of oil or hydrophilic liquids in a wide variety of other applications, and the above disclosure it is not meant to necessarily limit the use of the webs of the present invention to any specific uses.

10 Referring now in more detail to the figures, Figure 1 illustrates a fibrous web 10 of the present invention having a horizontal planar dimensions demonstrated by axis x-x and y-y, and thickness, t, in the z-z axis. Web 10 has top surface 12, having a thin thermally bonded layer 13 and bottom surface 14 having a thin thermally bonded layer 15. Figure 2 illustrates a cross sectional view of Figure 1. Figures 1 and 2 are for illustrative purposes and are not intended to demonstrate actual scale.

Figure 4 shows a flow chart of a process for making preferred fibrous webs. Fibers, not shown, enter carding machine 40 and are carded onto moving belt 42. 15 Moving belt 42 transports the web to cross lapping machine 43, such as a festooning machine, which cross laps the carded web to increase basis weight and increase the ratio of cross direction strength to machine direction strength. Cross lapped web is then transported along belt 42 to a first needling station 44, where needling is applied to the top surface of the web only ("tacking"), and next to a second needling station 45 where 20 needling is applied to both top and bottom surfaces of the web. Conventional needling equipment as is well known in the art can be used. After needling is completed, the web is thermally bonded on the top surface by thermal bonding machine 46 and on the bottom surface of the web by thermal bonding machine 50. Thermal bonding machines 46, 50, respectively have heated belts 47, 51 that travel around rolls 48, 49, 52, 53. Heated belts 25 are heated to the desired thermal bonding temperature for the polymeric fibers. The fibers are heated to a temperature of about or greater than the  $T_g$  or  $T_m$  of the polymer to be melt bonded. In order to minimize densification, low or minimal pressure should be applied by the rolls 48, 49, 52, 53 and belts 47, 51. Preferably the gap between the belts 47, 51 is approximately the same as the thickness of the web, such that both belts contact 30 the web, but do not excessively compress the web.

## Test Procedures

### Oil Absorbency Test Method

5 The Ambient Temperature Oil Absorbency, High Temperature (120 C) Oil Absorbency, and High Temperature (175 C) Oil Absorbency Values of the fibrous web is determined according to the test as follows. Ambient Temperature Oil Absorbency is determined at 22 C.

10 First, 48 ounces of CRISCO® vegetable oil (UPC 37000-00482, The Procter & Gamble Company, Cincinnati, Ohio) or equivalent are placed into a rectangular, flat bottom glass bowl having dimensions of 9.0 inches (22.9 cm) by 10.0 inches (25.4 cm) (e.g., PRYEX® Part No. 3140, Corning Inc. (Corning NY), or equivalent). A stir bar is placed in the bowl containing the vegetable oil and the bowl is placed on a stirrer/hot plate (stirrer/hot plate Model PC 620, manufactured by Corning Inc., Corning, NY, or equivalent). The oil is heated with stirring until the oil reaches the desired temperature 15 (120 C or 175 C). The target temperature for ambient absorbency (22 C) may be achieved by heating, or cooling, as may be appropriate. Throughout the test, temperature of the oil is controlled to within +/- 3 C degrees. A 10 cm by 10 cm square sample of the fibrous web is prepared and the mass is measured to within plus or minus 0.1 gram. The fibrous web is placed onto a 12.7 cm by 12.7 cm square stiff metal screen (0.6 mm diameter 20 aluminum metal wire, rectangular weave woven screen with 1.27 cm spacing between wires measured wire center to center), lowered into the oil keeping the screen horizontal, kept submerged in the oil for 30 seconds, and removed from the oil keeping the screen horizontal. The screen is then held at a 45 degree angle for 3 to 5 seconds, returned to horizontal and allowed to drain for 15 seconds. The mass of the saturated fibrous web is 25 then measured. The difference between the mass of the fibrous web before and after oil absorption is then calculated to determine the amount of oil absorbed. The Oil Absorbency Value is calculated by dividing the mass of oil absorbed by the original, pre-oil saturation mass of the 10 cm by 10 cm sample of the fibrous web and reported in units of gram per gram (g/g).

### Linting Value

The Linting Value of the fibrous webs of the present invention is determined as follows. The webs to be tested and tape to be used in testing are to be pre-conditioned for 24 hours, and the test method is to be conducted, at between 20 C and 25 C, inclusive, and between 40% and 60% relative humidity, inclusive.

Adhesive tape (SCOTCH® masking tape, 3M234-1, manufactured by the Minnesota Manufacturing and Mining Company, St. Paul, Minnesota) having a width of 2.54 cm is formed into adhesive test strips having a 2.5 cm x 2.54 cm adhesive portion and a 1.25 cm x 2.54 cm non-stick tab portion. The tab portion is formed by initially cutting the tape into 5.0 cm x 2.54 cm strips, and then folding a portion of the tape over on itself with the adhesive sides of the folded portion of the tape facing each other. The mass of each test strip is measured to within plus or minus 1 mg.

A sample of fibrous web to be tested is placed on a horizontal level surface. An adhesive test strip is lightly (without application of normal force generated by the operator's hand) placed onto the web with the adhesive side of the test strip facing the web. The test strip should be placed at least 1 cm away from the edge of the web. A 50 m wide, 4100 g roller is then rolled across the tape in the direction parallel to the short axis of the non-stick tab portion a total of four (4) times, starting with the non-stick tab portion of the test strip, then reversing direction, and repeating for a total of two (2) times in each direction. The roller should be rolled onto the test strip by placing the roller on the web or surrounding surface and rolling it onto the test strip. The roller should be rolled by pulling it by its handle with the handle maintained in a position horizontal to the surface so as to avoid operator-induced upward or downward forces. The roller is rolled at rate of about 1.4 cm/s (about 1 second of contact between the roll and the test strip per pass). No portion of the roller should extend beyond the edge of the web when it is being rolled over the test strip. The test strip is removed from the web using one hand to pull the test strip by the non-stick tab directly upward (perpendicular to the surface) with even force applied over a period of 2 seconds while holding the web down along both sides of the test strip that are parallel to the short axis of the no-stick tab (i.e., parallel with the direction the test strip is peeled from the web). The mass of the linted test strip is



measured to within +/- 1 mg. The amount of lint adhered to the test strip is calculated by subtracting the original mass of the test strip from the mass of the linted test strip. The test is repeated 11 more times, for a total of 12 times for each product. The average is calculated and reported as the Linting Value in units of mg.

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#### Caliper, Density and Basis Weight Methods

All caliper, density, and basis weight measurements of the webs of the present invention should be measured according to the following methods.

Web materials to be measured should be pre-conditioned for 24 hours at 20 C to  
10 25 C, inclusive, and 40% to 60% relative humidity, inclusive. Caliper is measured accurate to +/- 0.001 mm at a pressure of 15.8 g/cm<sup>2</sup> applied over a 2.54 cm diameter circular flat bottom foot using a caliper dial indicator. The sample of web to be measured should be large enough to completely cover the area of the flat bottom foot. A balance to be used should be accurate to +/- 0.01 g.

15 Procedure: Cut web sample to desired size and place on a flat anvil surface of the caliper dial indicator stand. Determine caliper using the caliper dial indicator (such as a Model ID C12E Electronic Dial Indicator from Mitutoyo Corp., Kanagawa, Japan, or equivalent). Measure mass of the web sample. Calculate density as (sample mass)/[(area of top surface of sample) x (caliper)]. Basis weight can determined by multiplying  
20 density by caliper.

Although particular versions and embodiments of the present invention have been shown and described, various modifications can be made to this absorbent fibrous web without departing from the teachings of the present invention. The terms used in describing the invention are used in their descriptive sense and not as terms of limitation,  
25 it being intended that all equivalents thereof be included within the scope of the claims.